ing and the second			<del></del>	n na naza		alip	waln
•	er ID 109065 er 08, 2013 2:51:17 PM		*109	065*		50'	Page 1
Revision ID:	D3186-4 Spacepod Door, RH		Accept	*N900040	100*	Setup Start	וכימו
Required Date:	11/8/2013 Start Qty: 1 11/8/2013 Req'd Qty: 1	•		Cust Item ID: Customer:			14(7)
Approvals:	Process Plan: MF.	Date:	Tooling: SPC (Y/N):	Date:		Run Start	"NRT"
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Acco	- 0	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr		-				
D3186	Rev E						
* <b>14</b> 0 * <b>14</b> 0* QC Quality Control		10 PECT RA 111639 D3186-4 B 1000. DS MINOR REPAIR	0.00 0.00 <b>68/5</b> 37 <b>91</b>	DAS 16 9-89 /3 /u/11			
*150 *150* Small Fab Small Fab	<b>Men</b> REP. (FIL)	• 10 AIR IN ACORDANCE WITH CUS L LOWER HINGE HOLES PER QS	0.00  0.00  TOMER REQUEST SI 037)		- <b>/</b>		04s 05//3·//·/
<sup>160</sup> *16∩*	QC5- Inspect part	t completeness to step on W/O	0.00 DAS 27 9-89		)		
QC Quality Control	Mem	10	0.00 13 11 13	2)		<u> </u>	

											DQA:	Date	:: <u> </u>
NCR: Y	/es	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UP	DATE			•
										· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date	:
Work Orde	or.					DISPOSITION		1		AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	f Therm	Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
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Landi		Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled			Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in		rube	F	Drill Holes	$\vdash$	Misread Offset	•	<b>L_</b>	J. Ower 2033/	Juige	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Friday, November 08, 2013 2:51:17 PM Item ID: D3186-4 Accept \*N900040100\* Setup Start **Revision ID:** Spacepod Door, RH Item Name: Start Qty: 1.00 **Start Date:** 11/8/2013 **Cust Item ID:** Required Date: 11/8/2013 **Req'd Qty:** 1.00 **Customer:** Reference: REWORK Run Process Plan: **Approvals:** Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Reject Set Up/ Tool ID Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 170 Identify as per dwg & Stock Location: 0.00 \*170\* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 MCS 13-1-13 MCS (3-11-13 \*180\* QC 0.00 Memo Quality Control

NCR:	Yes	1	No
NUK:	162	1	NO

Date:

ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
							,					QA Closed:	Date		
Vork Orde	er:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	•					ı	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.					١	Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	•						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	Ю.		<u></u> <u></u> .			1	Work Order Update			Large Fab	Composite		Supplier		
				, , ,								1	· · · · · · · · · · · · · · · · · · ·	7	
Root		!			Descr	•	ion of work order update	1	nitial		tion	Sign &			
Cause	4	Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
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Landi	na (	Gear					General	AUL	. CATE	-					
Lanui	[ ]	Bending			Г	$\neg$	Bend	Г	Grain		Γ	Ovalized		Pressure/Forced	
	┢	Centre No	nt Concei	ntric to	0/5	_	BOM/Route	$\vdash$	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure	
	$\vdash$	Cracks			·, ·	_	Broken/Damaged	$\vdash$	i	on Incomplete	-	Part Incorre	<del></del>	Weld	
		ł	Crimped		F	_	Burrs		4 `	ions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled	
	$\vdash$	Crushed/Crimped Burrs Cuffs Contamination					Mainte	•		Part Moved		ı			
	$\vdash$	Heat Trea	at .		F	_	Countersink		Mislabe		<u> </u>	Positioned			
		inspectio		Tube	 	_	Cut Too Short		Misread		<u> </u>	Power Loss,		Other	
	Г	Ripples in			r	-	Drill Holes		Offset		<b>L</b>		- <b>L</b>		
		Torque W		extrusio	n		Drawing		Out of	Calibration					
	Г	Turning S					Finish		Out of	Sequence					
	Wave/Twist in Tube Folio						Folio		Outside Dimensions						

### Picklist Print

\* Friday, November 08, 2013 2:51:16 PM

Work Order ID:

109065

Parent Item:

D3186-4

Parent Item Name:

Spacepod Door, RH

Start Date: 11/8/2013

Required Date: 11/8/2013

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec door before drilling DD verf:EC

IPP Rev:C 10-08-11 added trim

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-4 Spacepod Door RH		Manufactured	No		•	•	Each	0.0000	•	1			

1 × 3100037,

QA:	Date:	٠.,	•

NCR: Yes / No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

									QA Closed:	Date	e:
Work Order	·.	•			DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part No Us  NCR No Work Order U						] Th∈	Skid-tube  Machining rmoforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											}
Operator	7							:			
Material											
Setup											
Other		ļ				1					
Process							•				
Supplier											
Training											
Jnapproved		<u> </u>									
					F	<b>AULT CA</b>	TEGORY				
Landin	g Gear				General	_		_	•	_	_
	Bending				Bend	Grai	n		Ovalized	L	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s [_	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct [	Weld
	Crushed/	Crimped			Burrs	Instr	uctions Incomplete	:/Unclear	Part Lost/Mi	issing [	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Trea	at			Countersink	Misla	beled	L	Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offse	et				
	Torque V	Vaves in 1	Extrusio	n [_	Drawing	Out	of Calibration				
	Turning S	Sequence			Finish	Out	of Sequence				
	Wave/Tv	vist in Tul	be		Folio	Outs	ide Dimensions				

# RA 111639 D3186-4 B100037

Received @ Dart, 2013-10-25 Inspected@ Dart, 2013-11-08 Customer: ARROW HELICOPTERS Customer Contact: TONY KUTENBACH Shipped from: REVELSTOKE, AB.

\* 169015

#### Instructions for RA 111639 D3186-4 B100037

- Open up a work order to inspect & repair D3186-4
- Repair in accordance with customer request (fill lower Hinge Holes) per QSI 037
- Re identified with new batch number
- Return to customer

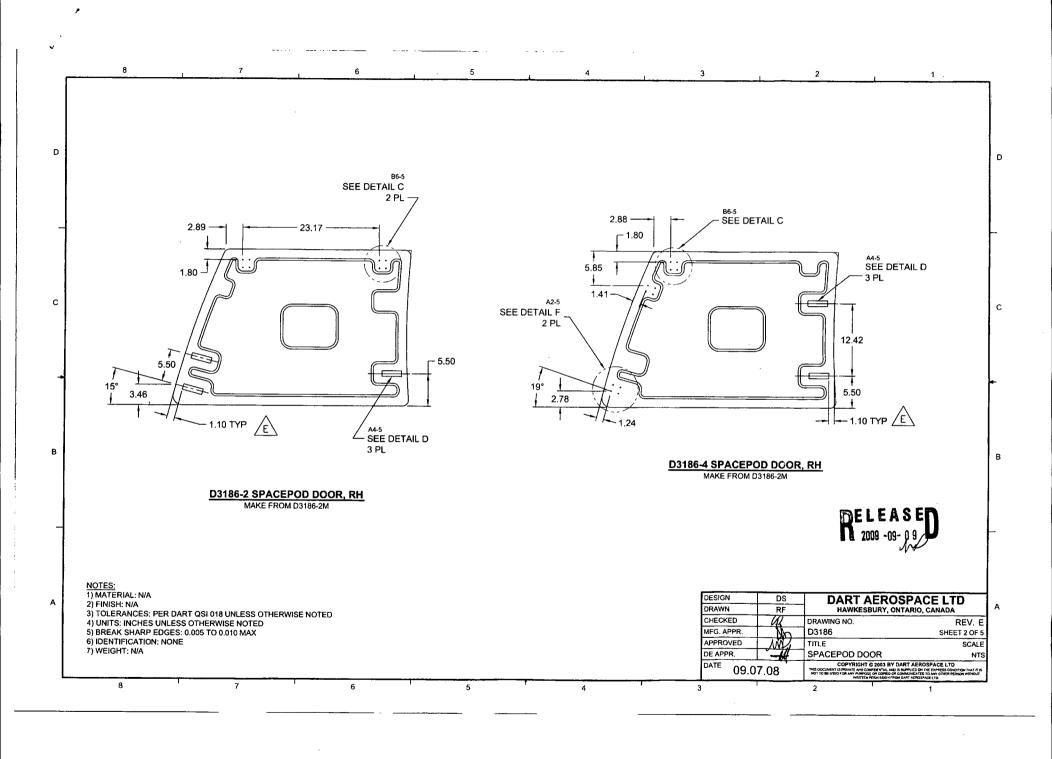
<u>Time Estimate</u> = 2 HOUR ONLY (stores)

Departments Required Finishing (composite repair)

Pictures Attached = NO

QTY INSPECTED = x1 D3816-4

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!



NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDA	AI E		5.	ų.		
			· · · · · · · · · · · · · · · · · · ·					ř			QA Closed:	Date	:		
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Scrap Machining S Use-as-is Thermoforming			Crosstube Small Fab Finishing Composite	Ill Fab Prod. Eng. Coor. Quality ishing Rec/Store/Packaging Other					
Root					Descri	ption of work order update		Initial	Action	1	Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Descript	ion	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FAUI	LT CATE	GORY						
Landi	ing (	Sear				General									
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		<b>⊣</b> '	on Incomplete ions Incomplete/Unc nance led	lear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
I	1	Torque V	Vaves in I	Extrusion	, I	Drawing	1	Out of (	alibration				•		

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

## RA 111636 D119-827-011 B97984

Received @ Dart, 2013-10-24 Inspected@ Dart, 2013-11-08 Customer: AugustaWestland Customer Contact:ANITA COELHO Shipped from: Philadelphia .PA

#### Instructions for RA 111636 D119-827-011 B97984

- Open up a work order to inspect & repair D4711-041
- Material needed D4749-1
- Verified the material and inspect QC
- Re identified with new batch number
- Return to customer

<u>Time Estimate</u> = 2 HOUR ONLY (stores)

**Departments Required small fab** (restocking)

Pictures Attached = NO

## THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!